

Date: Friday, 01/06/2007 9:23:19 AM  
User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: B29376
Job Number	: 32733		
Estimate Number	: 10804		
P.O. Number	: <i>NIA</i>	Part Number	: D212722011
This Issue	: 01/06/2007 S.O. No. : <i>NIA</i>	Drawing Number	: REWORK
Prsht Rev.	: NC	Project Number	: <i>NIA</i>
First Issue	: 01/06/2007 Type : SMALL / MED FAB	Drawing Revision	: <i>NIA</i>
Previous Run	: 00015	Material	: <i>NIA</i>
Written By	: _____	Due Date	: 08/06/2007
Checked & Approved By	: _____	Qty:	1 Um: Each
Comment	: _____		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
PULL FROM STK:  
1 X D212-722-011 B29376

2.0	D212722011	Avionics Console
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Avionics Console

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
REWORK:

- DRILL OUT EXISTING D3362-1 RAIL (2 PLACES)
- DRILL OUT EXISTING D3360-3 ANGLE (2 PLACES)
- FILE LARGE RECTANGULAR SECTION TO ALLOW FOR FIT OF RACK
- INSTALL NEW D3360-3 ANGLE (2 PLACES), AND CHECK FIT *B# M104629*
- FILL HOLES WHERE D3362-1 RAIL INSTALLS, WITH WELD
- ROD B *M102756* *07-06-28*
- USING RADIO RACK AND DZUS RAIL- DRILL HOLES FOR D3362-1 *N2W B#*
- DEBURR - 16X RIVETS *MS20426 AD4-5 M3459* *12566* *x2* *MS20426 AD4-6* *12566*

*Replace 2X rail*  
*D3362-1*  
*M 17763*

*FF 07-06-28*

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP  
VERIFY PARTS FIT - SEE PETER HUM

*RH 07-07-06*

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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: B29376

Job Number: 32733

Part Number: D212722011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
TOUCH UP WITH ALODINE

FF. 07-06-28

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP D212-722 CHG 002

USING NEW B/N

NEW PAPERWORK & LABELS REQ'D

Per D

7/7/05

8.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

(1)

07/07/06

Job Completion



W A. 07.06



Re: D212-722-011 B29376

Re-work scheme

- 1) Drill out existing D3362-1 rail (2 places)
- 2) Drill out existing D3360-3 angle (2 places)
- 3) a) file large rectangular section to allow for fit of rack  
b) Install new D3360-3 angle (2 places), check fit
- 4) Fill holes where D3362-1 rail installs with weld.  
Using radio rack and Dzus rail, + drill holes for D3362-1
- 5) ~~Fit~~ Deburr and touch up
- 6) Verify parts fit

Peter 

## Peter Hum

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** January 22, 2007 11:06 AM  
**To:** 'Peter Hum'  
**Subject:** RE: D3363 avionics console re-work

Your rework scheme is acceptable to me.

David

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**From:** Peter Hum [mailto:phum@dartaero.com]  
**Sent:** Wednesday, January 17, 2007 11:46 AM  
**To:** 'David Shepherd'  
**Cc:** 'S Shahbazian'  
**Subject:** D3363 avionics console re-work

David,

It was brought to the attention of Serge from Tom McBride @ Eagle that the D212-722 Avionics Console we make does not fit the radios. Tom sent us the parts that need to fit into the console.

Production made 10 on the waterjet before we found out about this.

In order to make the radio racks fit, I am proposing the following:

- 1) The DZUS rails that rivet to the top rack are not wide enough. Can we fill the mounting holes with weld and transfer drill an assembled DZUS rail and radio thru the console and then rivet? See attached pictures
- 2) The larger rectangular portion is not wide enough. Can we file the inside edges to allow the better fit. Then we will test fit before riveting using the parts Tom McBride sent us

Can the D3363-041 be re-worked as described above?

Peter

P.S. We will update the flat pattern

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No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.410 / Virus Database: 268.16.13/632 - Release Date: 1/16/2007

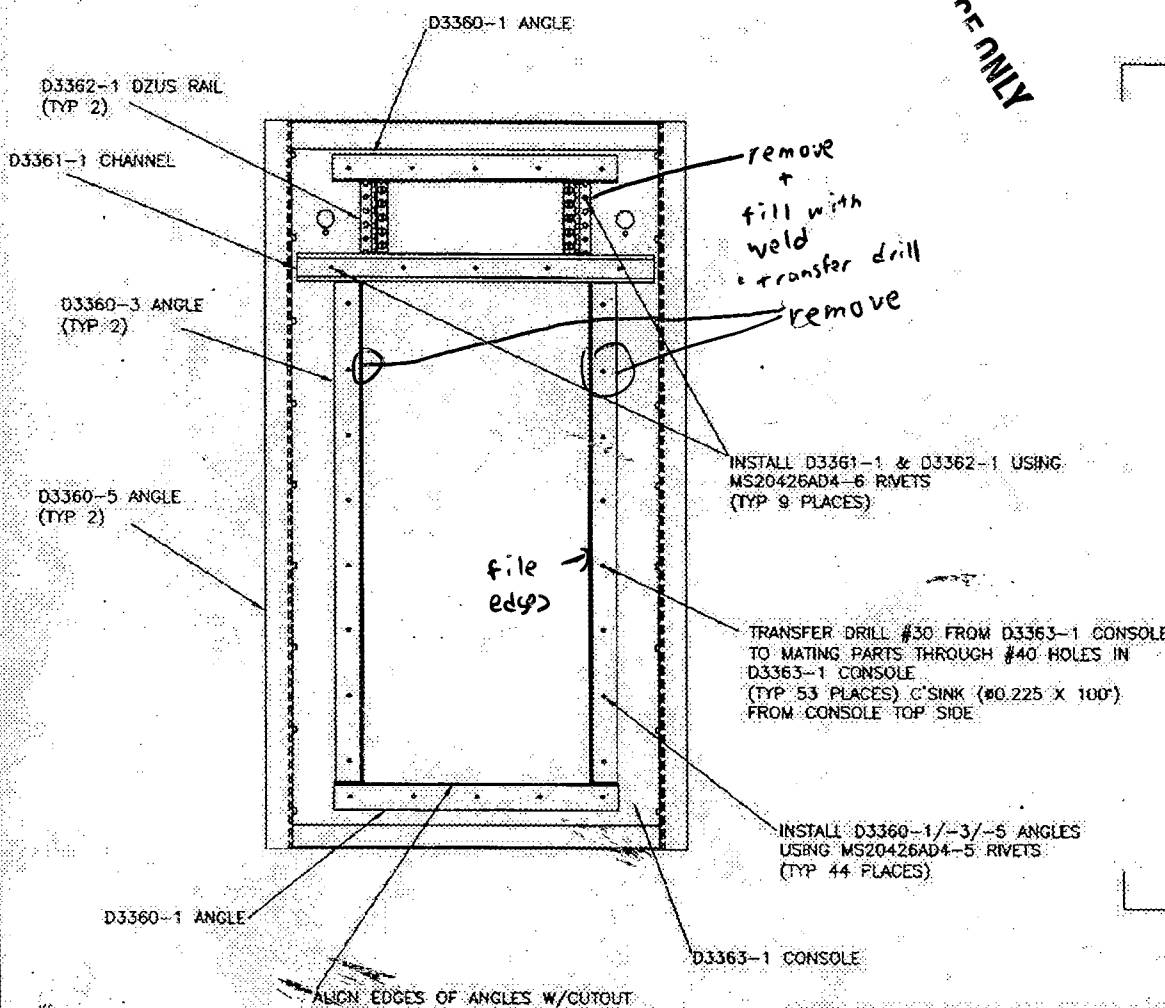
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No virus found in this outgoing message.  
Checked by AVG Free Edition.  
Version: 7.1.410 / Virus Database: 268.17.3/642 - Release Date: 1/20/2007

24/05/2007

**DART**

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B
CHECKED	PH	APPROVED	PH	DRAWING NO.	D3363	SHEET 1 OF 3
DATE	05.03.28	TITLE	CONSOLE ASSEMBLY	SCALE	1:5	
A	04.11.29	NEW ISSUE				
B	05.03.28	INCREASE WIDTH BY 0.125				
C1	05.01.38	CHANGE WIDTH TO 10.430 WAS 10.43				

REFERENCE ONLY



VIEW A-A FROM UNDER CONSOLE ASSEMBLY

**PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY**

- D3363-041 CONSOLE ASSEMBLY**
- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
  - 2) IDENTIFY WITH DART P/N D3363-041 AND P/N 0XXXXX USING FINE POINT PERMANENT INK MARKER
  - 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

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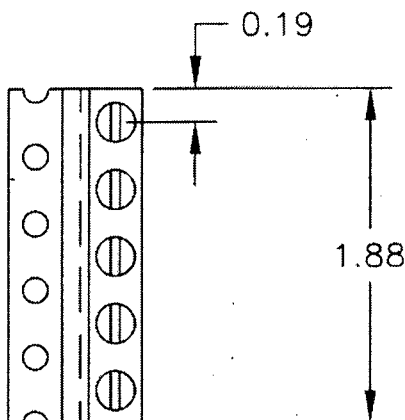
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**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3362	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE RAIL	SCALE 1:1
A	04.11.29	NEW ISSUE	

RELEASED

05.03.31 [Signature]



REFERENCE ONLY

REFERENCE ONLY

D3362-1 RAIL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MAKE FROM DZUS RAIL P/N "PR 3-1/2-1" OR PR-35-1
- 3) TOLERANCES ARE PER DART QSI 018
- 4) ALL DIMENSIONS ARE IN INCHES

REFERENCE ONLY

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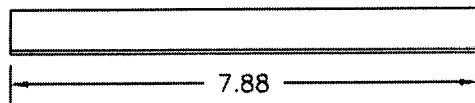
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DATE 04.11.29		TITLE ANGLE	SCALE 1:12
A	04.11.29	NEW ISSUE	

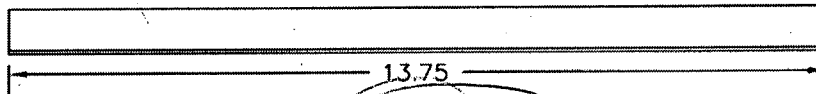
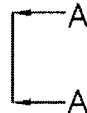
RELEASED

05-03-31 [Signature]

REFERENCE ONLY

D3360-1  
(SCALE 1:3)

REFERENCE ONLY

D3360-3  
(SCALE 1:3)0.25  
(TYP)70°  
(TYP)

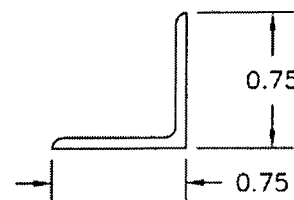
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D3360-5  
(SCALE 1:3)

REFERENCE ONLY

## D3360-1/-3/-5 ANGLE

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM  
STOCK SIZE: 3/4" x 3/4" x 0.063" ANGLE EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SECTION A-A  
(SCALE 1:1)

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